

5/04

SPLIT

DART AEROSPACE LTD	Work Order:	22032 A
Description: Fuel Purge Canister	Part Number:	D3262-041
Dwg: D3262 Rev. A	Qty:	2 YR

Page 1 of 1

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler Note: (1) D3262-041 consists of (1) D3262-1; (2) D3262-3	TH	04.12.08	12
2	MV	Cut (2) blanks per (1) D3262-041 Cut blanks: 6.000" x 0.500" x 5.400" long Bar Material: 6061-T6/T651 (QQ-A-200/8 or 225/8) 0.500" thick (M6061T6B0.500x06.000) Identify for D3262-3 Batch: M11708	EN	04/12/15	10
3	MV	Machine as per Folio FA457 and Dwg D3262 Identify as D3262-3	EN	05/01/04	10
4	QC2	Inspect parts as they come off the CNC machine	EN	05/01/04	10
5	QC8	Second check	EE	05.01.12	10
6	MV	Deburr	GP	05/01/04	10
7	MV	Cut D3262-1 to length as per Dwg D3262 Material: 6061-T6 (QQ-A-200/8 or 225/8) 5.00 OD x 0.125" wall (M6061T6T5.000W.125) Identify as D3262-1 Batch: M15362	SG	05.01.12	4
8	WA	Weld canister assembly as per Dwg D3262 using DT8739 to align fillings Pick: Qty Part Number Description Batch A/R Aluminum Rod M15855	SE	05/02/22	2
9	QC5	Inspect work to Step 8	AB	05.02.22	2
10	PG	Issue P/O: For Liquid Penetrant inspection as per Dwg D3262, QSI 038 & as per ASTM E1417 Level 1 Possible Supplier: NDT Copy of NDT results is required.			
11	RG	Receive and Inspect for transit damage Ensure copy of NDT results are attached.			
12	QC6	Inspect for damage and ensure results are as per Dwg D3262 Pressure to 10 psi and submerge under water to check for leaks.	BB	05/02/22	2
13	FP	Chemical Conversion Coat as per QSI 005 4.1	ML	05/02/22	2
14	FP	Powder Coat Gloss White (Ref: 4.3.5.1) as per QSI 005 4.3 Ensure to mask threads	ML	05/03/03	1
15	QC3	Inspect Powder Coat	CL	05/03/04	2
16	ST	Identify with Dart part number and batch number using a fine point permanent ink marker, then Stock	CL	05/03/04	2
17	AC	Cost / part: 101.86 32518	Syc	05.03.08	2
18	DC	Close W/O 101.86 Inspect Level 21	OK	05.03.10	2

Rev	Date	Change	Revised By	Approved
A	04.09.02	New issue	KJ/JLM	
B	04.09.29	Added Steps 10-12; changed Step 16	KJ/JLM	JL

RELEASED

Work Order:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Manuf / Design Mgr	Approval QC Inspector	
02.05.22	10 & 11 12	CHANGE PROCEDURE AS PER Dwg D3262 REV. B.	TP			TP 05.02.22	18 05.03.09	

NCR		WORK ORDER NON-COMFORMANCE						
DATE	STEP	Description of NC section A	Corrective Action Section B	Sign & Date	Verification Section C	Approval Design Mgr	Approval QC Inspector	
05.01.11	3	10 parts scrap 9/16-18 UNF holes were tapped crooked operator error 	Initial Identify pieces as scrap and use for test welding operator retrained	05.01.11 B	05.01.12 B	05.01.12 B 05/01/12	AB 05/01/12	B 05.01.12

PAR#: PLAFault Category: PLADQA: TPDate: 05/03/09

DART AEROSPACE LTD	Work Order:	22032
Description: Cap	Part Number:	D3262-3
Inspection Dwg: D3262	Rev: A ^B A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

Measured by:	<i>E.P.</i>	Audited by:		Prototype Approval:	N/A
Date:	04/17/20	Date:		Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.09.03	New Issue P/O D3262-041	KJ/JLM	<i>[Signature]</i>

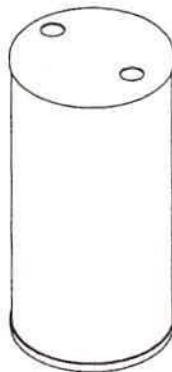
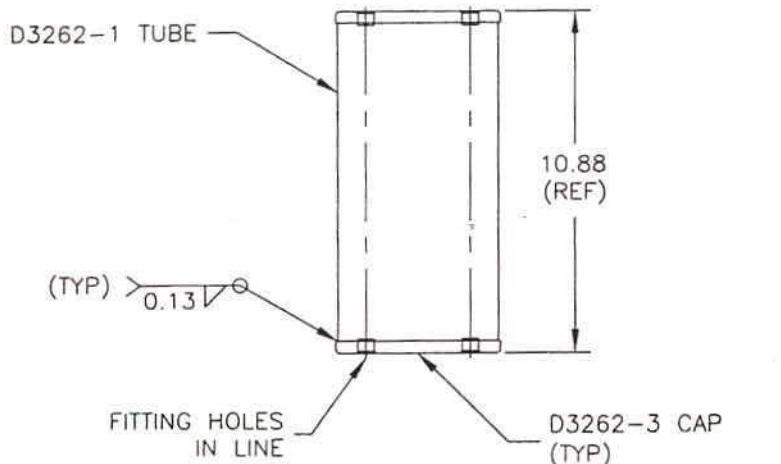
RELEASED
2004-09-03



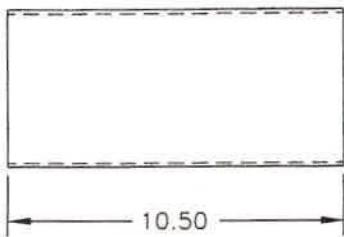
OF COPY ISSUED

DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED H	APPROVED H	DRAWING NO. D3262
DATE 04.05.06		REV. A SHEET 1 OF 2
	TITLE FUEL PURGE CANISTER	SCALE 1:1
A	04.05.06	NEW ISSUE

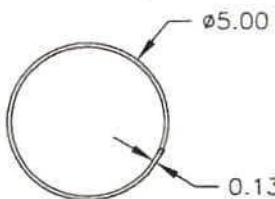
RELEASED
04-07-04 H



D3262-041 CANISTER ASSEMBLY



D3262-1 TUBE



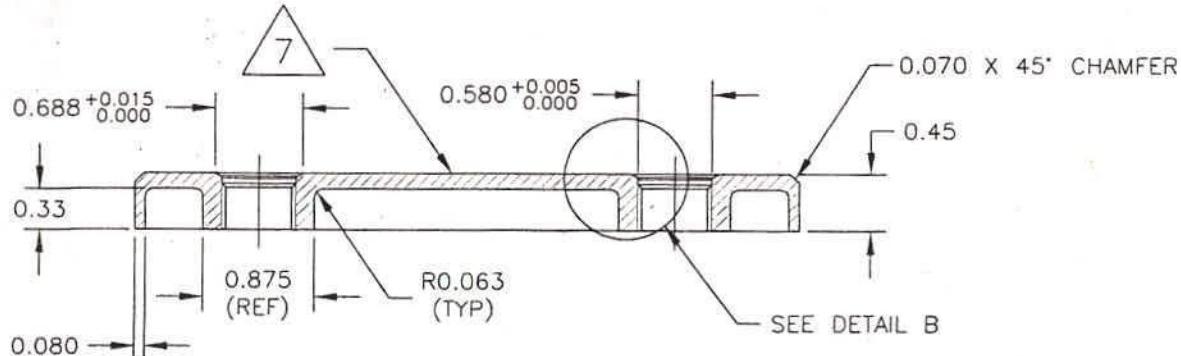
SHOP COPY
RETURN TO
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SUBJECT TO AMENDMENT
NOTICE
WORK ORDER
NO. 22032

D3262-041:

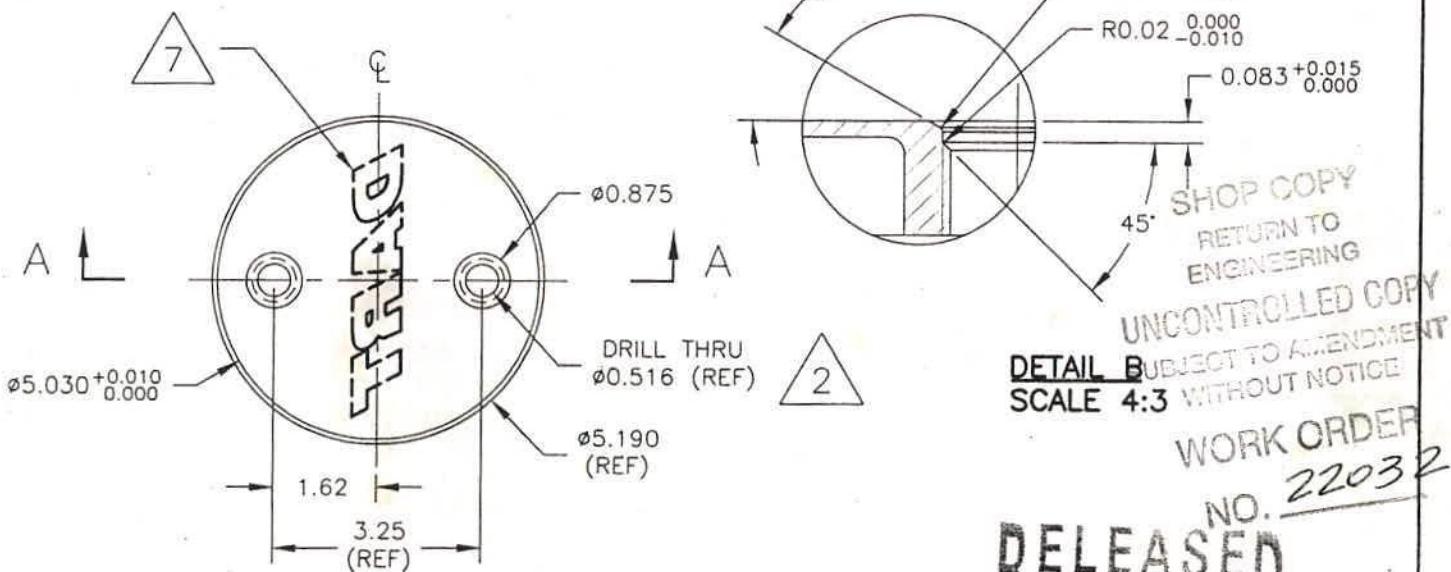
- 1) MATERIAL: 6061-T6 (WW-T-700/6 OR QQ-A-200/8 OR QQ-A-225/8)
TUBING 5.00 OD x 0.125 WALL (6061T6T5.000W.125)
- 2) WELD PER QSI 004.
- 3) LIQUID PENETRANT INSPECT PER ASTM E1417 LEVEL 1
- 4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 8) IDENTIFY WITH DART P/N & B/N USING FINE POINT PERMANENT INK MARKER

DART

DESIGN <i>RT</i>	DRAWN BY <i>RT</i>	DART AEROSPACE LTD	
CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO.	REV. A
DATE 04.05.06		D3262	SHEET 2 OF 2
		TITLE FUEL PURGE CANISTER	SCALE 1:3



SECTION A-A
SCALE 2:3



UNCONTROLLED COPY
DETAIL SUBJECT TO AMENDMENT
SCALE 4:3 WITHOUT NOTICE

WORK ORDER
22032

RELEASED
04.05.06 *[Signature]*

D3262-3

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8) BAR
(REF. DART SPEC. M6061T6B)
- 2) TAP HOLE 9/16-18 UNF-3B PER MIL-S-8879
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) PART IS SYMMETRIC ABOUT CENTERLINE
- 7) ENGRAVE DART LOGO AS SHOWN USING 0.75 HIGH x 0.010 DEEP
(MAX) LETTERS WITH (MIN) TOOL RADIUS OF 0.25